

Sup. 24602

Work Order ID 80402

80402

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February-21-12 7:51:52 AM

Item ID: D4212-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 429 Clamp Cushion

Start Date: 2/21/12

Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/22/12

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4212

C

100

0.00

100

Mill Conv

Conventional Milling Machine

Memo

Manual

0.00

1-Turn as per folio EA974 & dwg

FOLIO REV: _____

DWG REV: _____

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

12-2-22

12-2-23

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Page 2

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Setup Start

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Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

mk 12/02/23

8

130

Identify as per dwg & Stock Location: 460

0.00

130

Packaging

Memo

0.00

Packaging

12/2/23 sf

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/2/23
MF
12-02-23

Picklist Print

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Work Order ID: 80402

Parent Item: D4212-1

Parent Item Name: 429 Clamp Cushion

Start Date: 2/21/12

Required Date: 2/22/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-09-29 JLM VERIFIED BY:DD IPP REV:B 11.01.10 AS PER
DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1		Manufactured	No			100	f	35.0000	0.3708	4.6837895			
UHMW U-Channel													

Location

Loc Qty

Loc Code

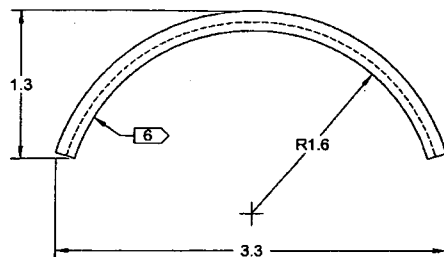
MAT055

35

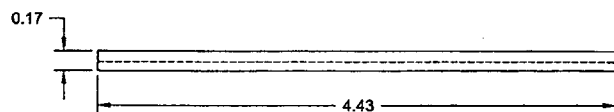
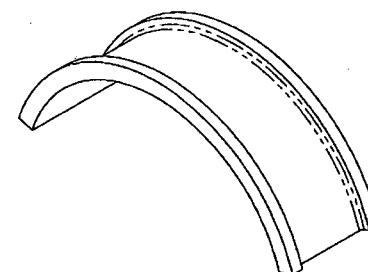
63828

35

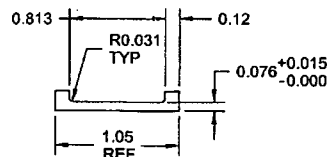
2.5 AD 12-2-22



D4212-1 CLAMP CUSHION
(MAKE FROM D4212-1F)




D4212-1F FLAT MACHINED STATE



RELEASED
2010-12-23

w/o 84102

- NOTES:**
- 1) MATERIAL: MAKE FROM D4287-1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4212-1" AND B/N "BXXXXX" PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

C	ADDED FLAT MACHINED STATE; CHANGED DIMENSIONS IAW MANUFACTURING PROCESS. REF: PAR10-29.	MB	10.12.07
B	REDESIGN TO REDUCE COST: "CLAMP CUSHION" WAS "429 CLAMP CUSHION"; MATL WAS MUHMMWTR3.509W.XXXW (ZN A7-1)	MB	10.10.28
A	NEW ISSUE	MB	10.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D4212	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CLAMP CUSHION	NTS
DATE	10.12.07	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	